

70204 SPLIT

Dart Aerospace Ltd.

Date: Tuesday, 05/06/2007 11:37:11 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32752
Estimate Number : 10580
P.O. Number : N/A
This Issue : 05/06/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 28600

Drawing Name : SPACER
Part Number : D2808
Drawing Number : D2808 REV A1
Project Number : N/A
Drawing Revision : A1
Material : N/A
Due Date : 05/06/2007

Qty: 80 40 Jm: E201

Written By :
Checked & Approved By :
Comment : Est Rev:D 02.03.07 Now turned in house NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0625 6061-T6 Round Bar .625"



Comment: Qty.: 0.0557 f(s)/Unit Total: 2.2260 f(s)
6061-T6 Round Bar .625"
(M6061T6R0625)
Batch: M103857

M8 07/06/06 40

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA205(Mesure D3387 Bracket .507" Dia for Proper press-fit)

2-Deburr

M8 07/06/06 40

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 07/06/06 40

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

7/6/06 40

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

5/2 07/06/06 40

S.I Powder Powder white.

M 104144

5/2 / BIK 07/06/08 40

Date: Tuesday, 05/06/2007 11:37:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 32752

Part Number: D2808

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pe 7/2/8 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 750

Pe 7/6/8 (40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(40) 1076/8

Job Completion

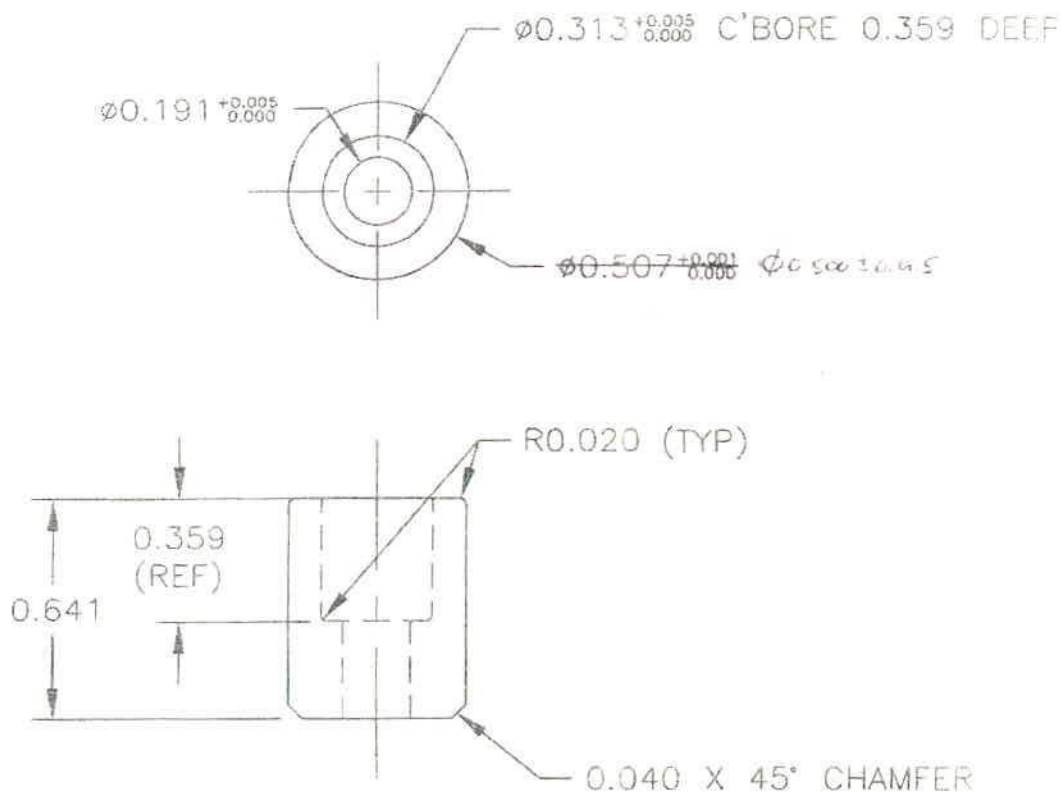


W 7-06-08



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED H	DRAWING NO. D2808	REV. A SHEET 1 OF 1
DATE 00.11.07	TITLE SPACER		SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	HIP 01.04.26	ADD POWDER COAT; $\phi 0.500$ WAS $\phi 0.476$	

RELEASED
11/13



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020

MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (435.1) OR GREY SANDTEX (435.6) OR BLACK SANDTEX (435.7)
OR GREEN SANDTEX (435.8) PER DART QSI 005 4.2

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.